

86277

Tuesday, June 26, 2012 1:39:53 PM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 6/26/2012 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 7/3/2012 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan:  Date: 12-06-24 Tooling:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr Revision Nbr

D3805

B

0.00

100

Large Fab

Large Fab

Memo

0.00

1- On D3806-3, fill cut outs with hardcoat welding rod as per dwg D3805

2059 B Hardcoat Welding Rod

BATCH#: m122030 → 2059B

2-weld D3806-3 to D3805-3 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: m120013

3-Transfer drill holes in bar

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

(X6) ml 12-06-28

Pl 12.06.28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86277

Tuesday, June 26, 2012 1:39:53 PM

86277

Page 2

Item ID: D3805-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 6/26/2012 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:20

OVEN TEMPERATURE: 320°F

FINISH TIME: 1:50

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

6X ϕ M/L 12/07/04

6 ϕ 1274

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 86277

Tuesday, June 26, 2012 1:39:53 PM

86277

Page 3

Item ID: D3805-043

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 6/26/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Small Fab

Memo

0.00

Small Fab

1- Bond D3807-3 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg
BATCH: m120904

6

φ

Ac

12.07.05

160

0.00

160

QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

8/26/05

46

170

0.00

170

Packaging

Identify as per dwg & Stock Location: FP-1

Memo

0.00

Packaging

6V φ M120904

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86277

Tuesday, June 26, 2012 1:39:53 PM

86277

Page 4

Item ID: D3805-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 6/26/2012 Start Qty: 6.00 ***6***

Cust Item ID:

Required Date: 7/3/2012 Req'd Qty: 6.00 ***6***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

CK 12/7/6

ME
12-07-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 26, 2012 1:39:53 PM

Page 1

Work Order ID: 86277

Parent Item: D3805-043

Parent Item Name: Wearplate Assembly Fwd, High Gear

Start Date: 6/26/2012

Required Date: 7/3/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevB: add transfer drill wearplate to bar DD 09.11.05 ver:EC IPP Rev:C 11.10.04 rev.b as per
dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3805-3 Plate		Manufactured	No				Each	2.0000					
	85845 x 6			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		2							
				77440		2							
D3806-3 Bar		Manufactured	No				Each	2.0000					
	85846 x 6			<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA030		2							
				74654		2							
D3807-3 Gasket		Manufactured	No				Each	17.0000					
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FP002		17							
				58572		9							
				<u>74655</u>		8							

(x6) 6 ml 12-06-26

(x6) 6 ml 12-06-26

6 Ae

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

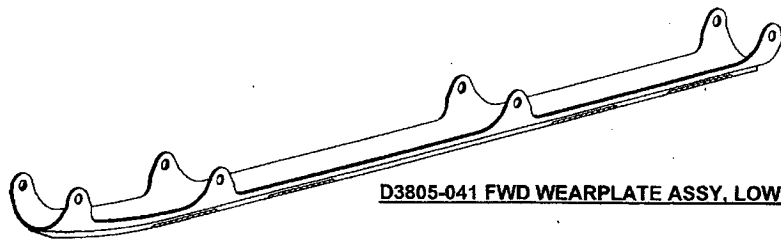
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

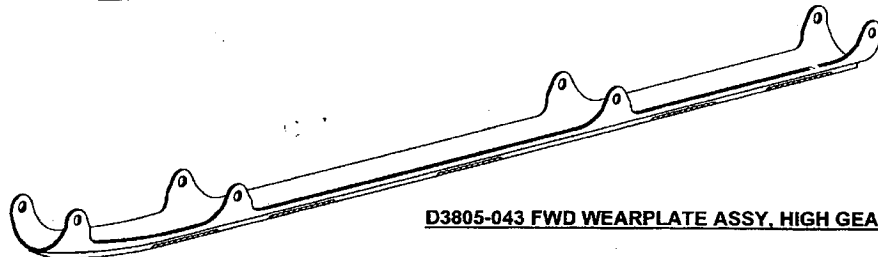
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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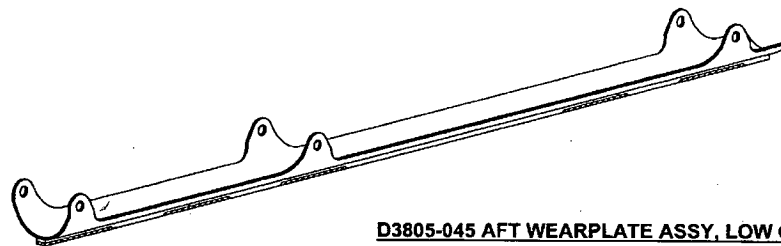
8 7 6 5 4 3 2 1



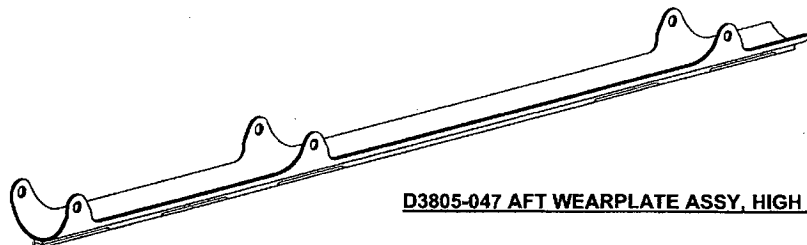
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PART11-106) AND RE-ORGANIZED NOTES SHEETS 2 & 3	MB	11.09.16
A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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86277
RELEASED
2011-10-03
MB

8 7 6 5 4 3 2 1

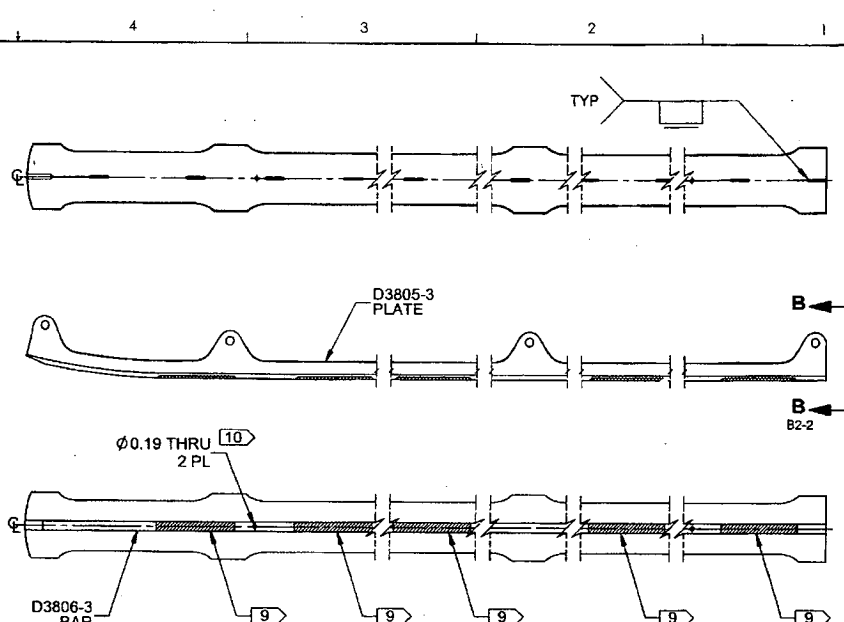
Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

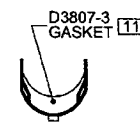
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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

D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



VIEW B-B C1-2

RELEASED
2011-10-03

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 4.18 lbs; D3805-043 = 4.78 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
- 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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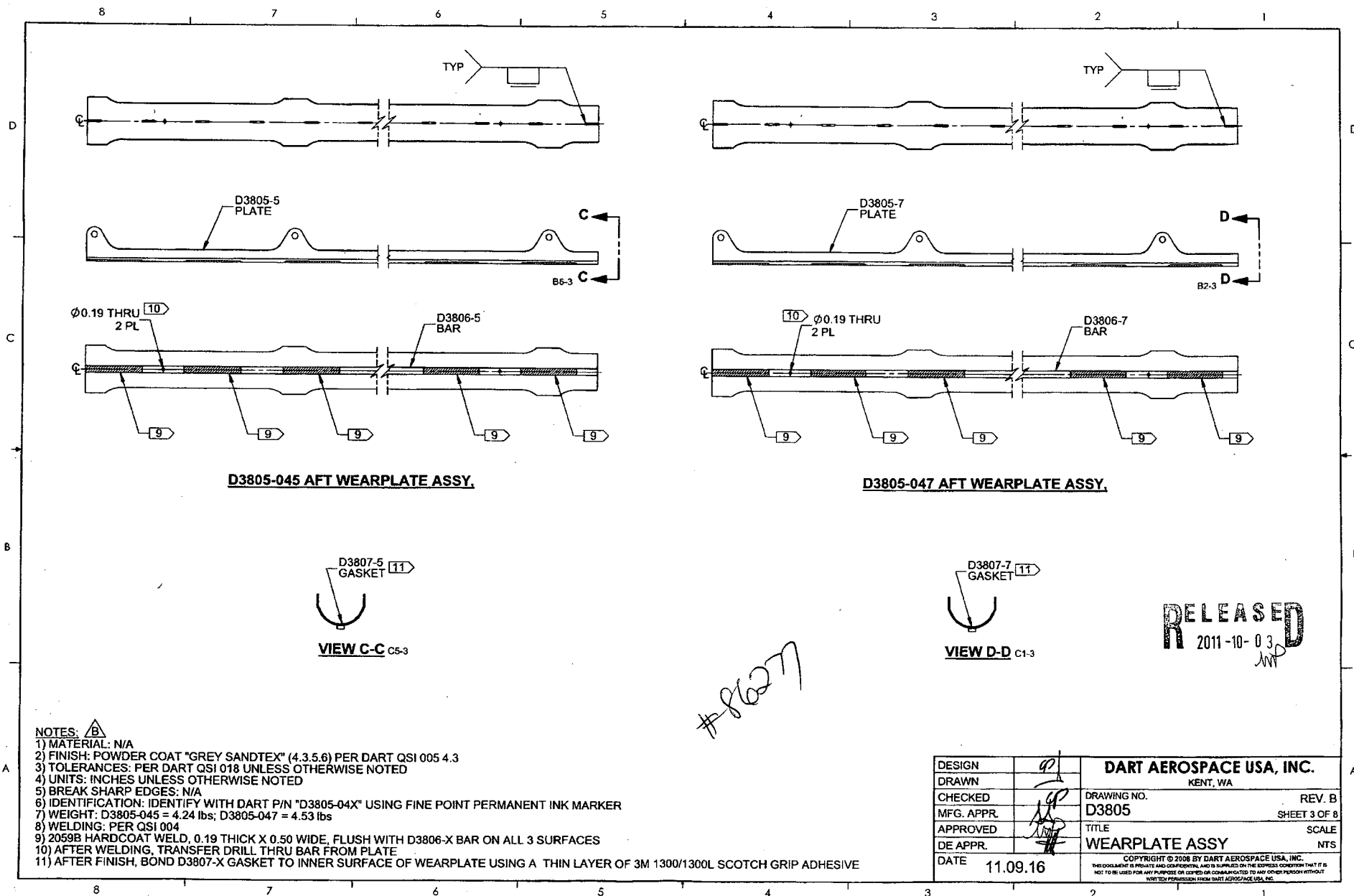
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd

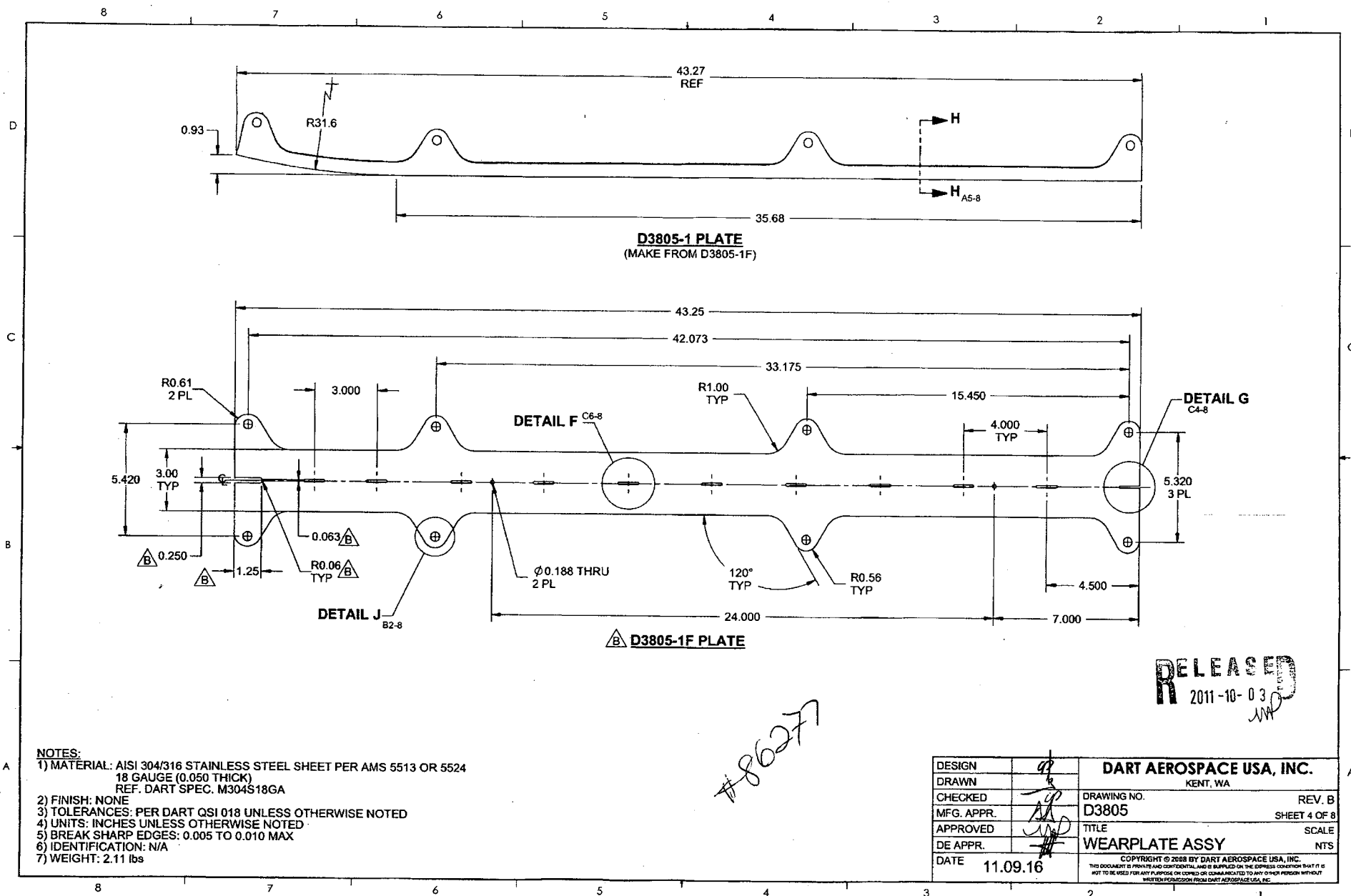
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



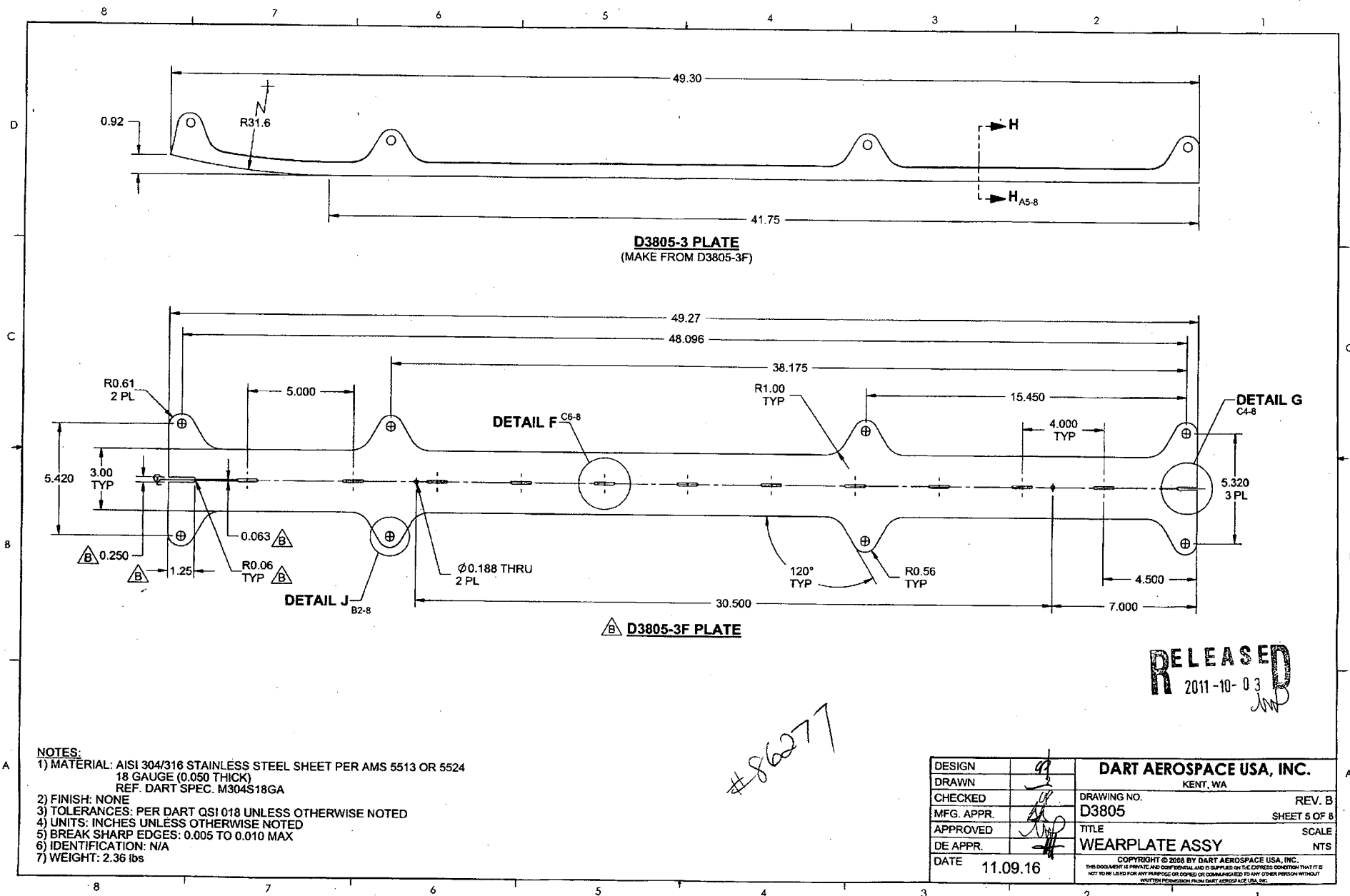
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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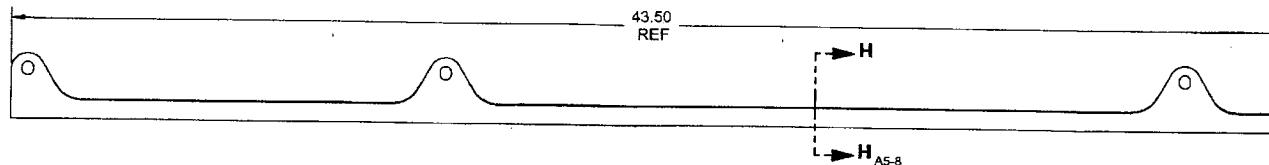
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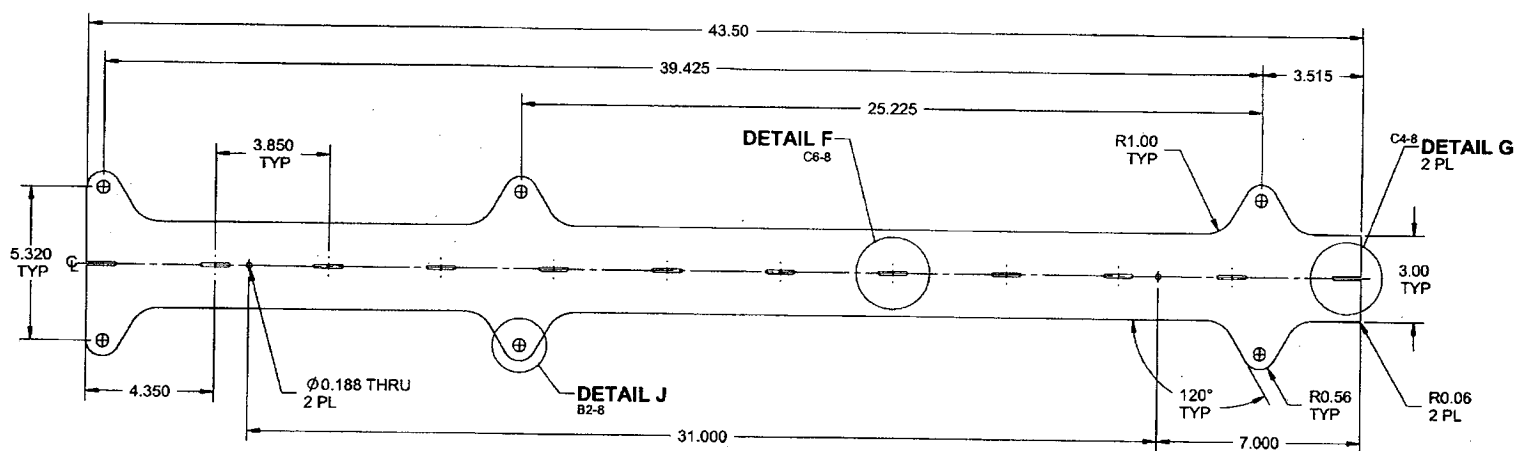
NOTE: Date & initial all entries



8 7 6 5 4 3 2 1



D3805-5 PLATE
(MAKE FROM D3805-5F)



D3805-5F PLATE

RELEASED
2011-10-03

#86277

NOTES:

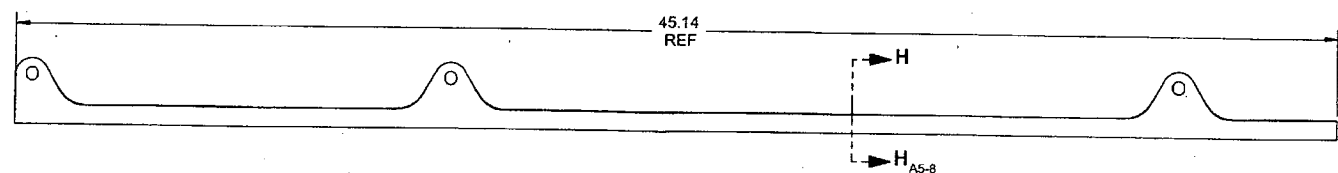
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 6 OF 8
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8 7 6 5 4 3 2 1

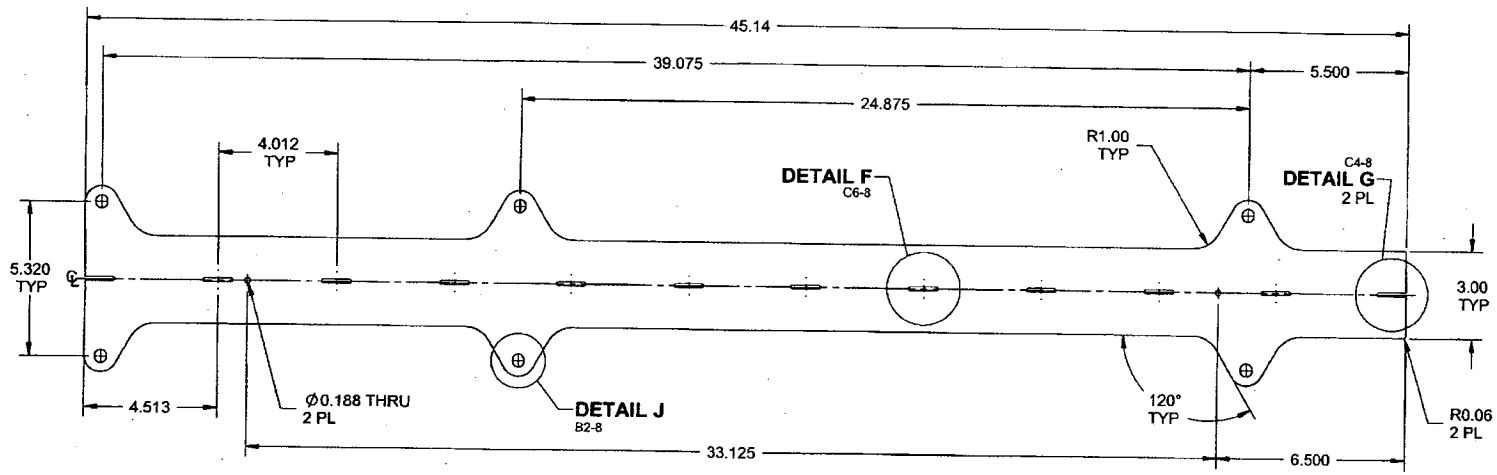
8 7 6 5 4 3 2 1

D



D3805-7 PLATE
(MAKE FROM D3805-7F)

C



D3805-7F PLATE

B

A

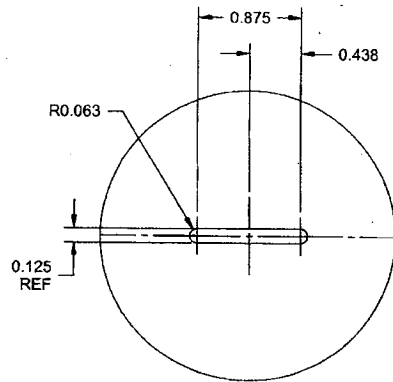
- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

86271

RELEASED
2011-10-03
NW

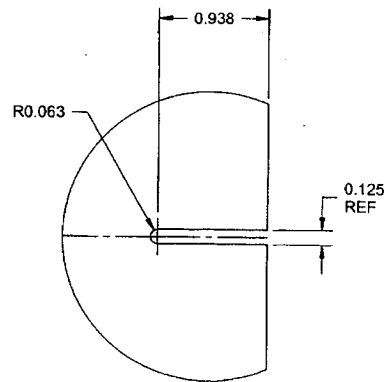
DESIGN		DART AEROSPACE USA, INC.	
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CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 7 OF 8
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8 7 6 5 4 3 2 1



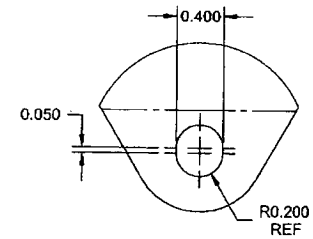
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



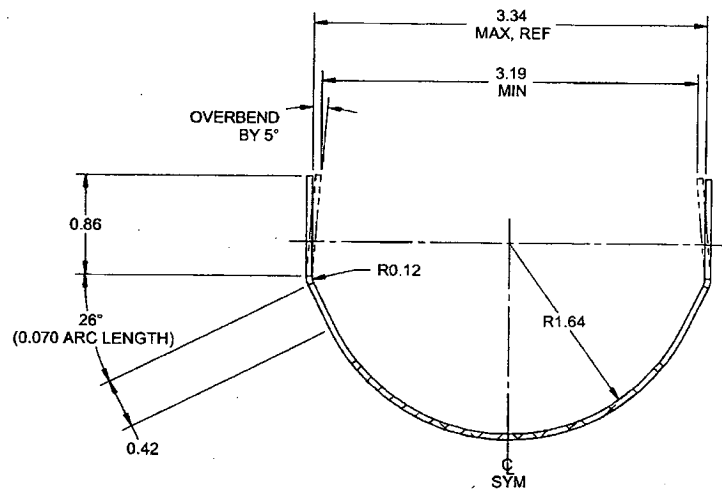
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 8 OF 8
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RELEASED
2011-10-02